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order # 9366

**D350-591-312**  
**Job Sheet 189012**



**Part No:** D350-591-312

**Job Qty:** 5 pcs

**Part Name:** Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 1/17/19

**Job Tracking No:**

**Due Date:** 2/27/19

**Created By:** Linda Lacelle

**Type:** SOLD

**Description:**

**Note:** DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation             | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|-----------------------|----------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                       |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Large Fab - Steps - 1 | 5<br>pcs | 2/27/19    |          | 0.00      | 5.00    | Large Fab - 1         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 10        |           |          |
|       |                       |          |            |          |           |         | Large Fab - 2         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 3         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 4         |           | DAS      |
|       |                       |          |            |          |           |         | Large Fab - 5         |           | 24       |
|       |                       |          |            |          |           |         | Large Fab - 6         |           | 9-89     |
|       |                       |          |            |          |           |         | Large Fab - 7         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 8         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 9         |           |          |
| 120   | QC 9                  | 5<br>pcs | 2/27/19    |          | 0.00      | 0.00    | QC 9 - 10             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 18             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 24             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 43             |           | DAS      |
|       |                       |          |            |          |           |         | QC 9 - 50             |           | 43       |
|       |                       |          |            |          |           |         | QC 9 - 9              |           | 9-89     |
| 130   | QC 5                  | 5<br>pcs | 2/27/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 12             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 17             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 18             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 19             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 22             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 24             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 3              |           |          |
|       |                       |          |            |          |           |         | QC 5 - 42             |           | DAS      |
|       |                       |          |            |          |           |         | QC 5 - 43             |           | 43       |
|       |                       |          |            |          |           |         | QC 5 - 49             |           | 9-89     |
|       |                       |          |            |          |           |         | QC 5 - 51             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 58             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 68             |           |          |

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|                                   |       |         |           |                           |             |  |  |  |                                           |
|-----------------------------------|-------|---------|-----------|---------------------------|-------------|--|--|--|-------------------------------------------|
| 140 Handfinish - 1-1 Chemical-B4B | 5 pcs | 2/27/19 | 0.00 0.94 | QC 5 - 9                  |             |  |  |  |                                           |
|                                   |       |         |           | QC 5 - 50                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 5 - 30                 |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 1 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 2 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 3 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 4 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 5 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 6 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 7 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 8 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 9 - B4B  |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 10 - B4B | DR 19/02/28 |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 11 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 12 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 13 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 14 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 15 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 16 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 17 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 18 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 19 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 20 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 21 - B4B |             |  |  |  |                                           |
|                                   |       |         |           | Handfinish - 1 - 22 - B4B |             |  |  |  |                                           |
| 150 QC 7                          | 5 pcs | 2/27/19 | 0.00 0.00 | QC 7 - 10                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 13                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 14                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 15                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 17                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 18                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 19                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 2                  |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 28                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 3                  |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 30                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 34                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 36                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 37                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 41                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 47                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 48                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 51                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 58                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 59                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 6                  |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 60                 |             |  |  |  |                                           |
|                                   |       |         |           | QC 7 - 9                  |             |  |  |  |                                           |
|                                   |       |         |           |                           |             |  |  |  | Plex 2/21/19 10:08 AM Dart.Hadley.Shannon |

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|                                    |          |         |           |                           |   |
|------------------------------------|----------|---------|-----------|---------------------------|---|
| 180 Large Fab - Steps - 2 - B4B    | 5<br>pcs | 2/27/19 | 0.00 5.00 | QC 7 - 68                 |   |
|                                    |          |         |           | QC 7 - 50                 |   |
|                                    |          |         |           | QC 7 - 67                 |   |
|                                    |          |         |           | Large Fab - 1 - B4B       |   |
|                                    |          |         |           | Large Fab - 10 - B4B      | X |
|                                    |          |         |           | Large Fab - 2 - B4B       |   |
|                                    |          |         |           | Large Fab - 3 - B4B       |   |
|                                    |          |         |           | Large Fab - 4 - B4B       |   |
|                                    |          |         |           | Large Fab - 5 - B4B       |   |
|                                    |          |         |           | Large Fab - 6 - B4B       |   |
| 190 QC 10                          | 5<br>pcs | 2/27/19 | 0.00 0.00 | Large Fab - 7 - B4B       |   |
|                                    |          |         |           | Large Fab - 8 - B4B       |   |
|                                    |          |         |           | Large Fab - 9 - B4B       |   |
|                                    |          |         |           | QC 10 - 10                |   |
|                                    |          |         |           | QC 10 - 18                |   |
|                                    |          |         |           | QC 10 - 24                |   |
|                                    |          |         |           | QC 10 - 43                |   |
|                                    |          |         |           | QC 10 - 50                |   |
|                                    |          |         |           | QC 10 - 58                |   |
|                                    |          |         |           | QC 10 - 9                 |   |
| 200 QC 5                           | 5<br>pcs | 2/27/19 | 0.00 0.00 | QC 5 - 10                 |   |
|                                    |          |         |           | QC 5 - 12                 |   |
|                                    |          |         |           | QC 5 - 17                 |   |
|                                    |          |         |           | QC 5 - 18                 |   |
|                                    |          |         |           | QC 5 - 19                 |   |
|                                    |          |         |           | QC 5 - 22                 |   |
|                                    |          |         |           | QC 5 - 24                 |   |
|                                    |          |         |           | QC 5 - 3                  |   |
|                                    |          |         |           | QC 5 - 42                 |   |
|                                    |          |         |           | QC 5 - 43                 |   |
|                                    |          |         |           | QC 5 - 49                 |   |
|                                    |          |         |           | QC 5 - 51                 |   |
|                                    |          |         |           | QC 5 - 58                 |   |
|                                    |          |         |           | QC 5 - 68                 |   |
|                                    |          |         |           | QC 5 - 9                  |   |
|                                    |          |         |           | QC 5 - 50                 |   |
|                                    |          |         |           | QC 5 - 30                 |   |
| 210 Handfinish - 1-2- Chemical-B4B | 5<br>pcs | 2/27/19 | 0.00 0.94 | Handfinish - 1 - 1 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 2 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 3 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 4 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 5 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 6 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 7 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 8 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 9 - B4B  |   |
|                                    |          |         |           | Handfinish - 1 - 10 - B4B |   |
|                                    |          |         |           | Handfinish - 1 - 11 - B4B |   |
|                                    |          |         |           | Handfinish - 1 - 12 - B4B |   |
|                                    |          |         |           | Handfinish - 1 - 13 - B4B |   |
|                                    |          |         |           | Handfinish - 1 - 14 - B4B |   |
|                                    |          |         |           | Handfinish - 1 - 15 - B4B |   |
|                                    |          |         |           | Handfinish - 1 - 16 - B4B |   |

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|     |                                 |       |         |           |                           |             |
|-----|---------------------------------|-------|---------|-----------|---------------------------|-------------|
|     |                                 |       |         |           | Handfinish - 1 - 17 - B4B |             |
|     |                                 |       |         |           | Handfinish - 1 - 18 - B4B |             |
|     |                                 |       |         |           | Handfinish - 1 - 19 - B4B |             |
|     |                                 |       |         |           | Handfinish - 1 - 20 - B4B |             |
|     |                                 |       |         |           | Handfinish - 1 - 21 - B4B |             |
|     |                                 |       |         |           | Handfinish - 1 - 22 - B4B |             |
| 220 | Powdercoat - 1 White Gl(A)- B4B | 5 pcs | 2/27/19 | 0.00 1.49 | Powdercoat - 1 - B4B      |             |
|     |                                 |       |         |           | Powdercoat - 2 - B4B      | BEB19-03-05 |
|     |                                 |       |         |           | Powdercoat - 3 - B4B      |             |
|     |                                 |       |         |           | Powdercoat - 4 - B4B      |             |
| 230 | Handfinish - 3-1- WingWalk- B4B | 5 pcs | 2/27/19 | 0.00 0.94 | Handfinish - 3 - 1 - B4B  | M 14-3-5    |
|     |                                 |       |         |           | Handfinish - 3 - 2 - B4B  |             |
|     |                                 |       |         |           | Handfinish - 3 - 3 - B4B  |             |
|     |                                 |       |         |           | Handfinish - 3 - 4 - B4B  |             |
|     |                                 |       |         |           | Handfinish - 3 - 5 - B4B  |             |
| 240 | QC 3                            | 5 pcs | 2/27/19 | 0.00 0.00 | QC 3 - 10                 |             |
|     |                                 |       |         |           | QC 3 - 13                 |             |
|     |                                 |       |         |           | QC 3 - 15                 |             |
|     |                                 |       |         |           | QC 3 - 17                 |             |
|     |                                 |       |         |           | QC 3 - 18                 |             |
|     |                                 |       |         |           | QC 3 - 2                  |             |
|     |                                 |       |         |           | QC 3 - 26                 |             |
|     |                                 |       |         |           | QC 3 - 28                 |             |
|     |                                 |       |         |           | QC 3 - 3                  |             |
|     |                                 |       |         |           | QC 3 - 30                 |             |
|     |                                 |       |         |           | QC 3 - 34                 |             |
|     |                                 |       |         |           | QC 3 - 36                 |             |
|     |                                 |       |         |           | QC 3 - 41                 |             |
|     |                                 |       |         |           | QC 3 - 51                 |             |
|     |                                 |       |         |           | QC 3 - 58                 |             |
|     |                                 |       |         |           | QC 3 - 59                 |             |
|     |                                 |       |         |           | QC 3 - 6                  |             |
|     |                                 |       |         |           | QC 3 - 68                 |             |
|     |                                 |       |         |           | QC 3 - 9                  |             |
| 250 | Packaging 1-1 - Pick Kit - B4B  | 5 pcs | 2/27/19 | 0.00 0.00 | Packaging 1 - 1 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 2 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 3 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 4 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 5 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 6 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 7 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 8 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 9 - B4B     |             |
|     |                                 |       |         |           | Packaging 1 - 10 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 11 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 12 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 13 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 14 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 15 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 16 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 17 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 18 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 19 - B4B    |             |
|     |                                 |       |         |           | Packaging 1 - 20 - B4B    |             |

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|                                 |          |         |           |                        |  |
|---------------------------------|----------|---------|-----------|------------------------|--|
|                                 |          |         |           | Packaging 1 - 21 - B4B |  |
|                                 |          |         |           | Packaging 1 - 22 - B4B |  |
|                                 |          |         |           | Packaging 1 - 23 - B4B |  |
|                                 |          |         |           | Packaging 1 - 24 - B4B |  |
|                                 |          |         |           | Packaging 1 - 25 - B4B |  |
|                                 |          |         |           | Packaging 1 - 26 - B4B |  |
|                                 |          |         |           | Packaging 1 - 27 - B4B |  |
|                                 |          |         |           | Packaging 1 - 28 - B4B |  |
|                                 |          |         |           | Packaging 1 - 29 - B4B |  |
|                                 |          |         |           | Packaging 1 - 30 - B4B |  |
|                                 |          |         |           | Packaging 1 - 31 - B4B |  |
|                                 |          |         |           | Packaging 1 - 32 - B4B |  |
|                                 |          |         |           | Packaging 1 - 33 - B4B |  |
|                                 |          |         |           | Packaging 1 - 34 - B4B |  |
|                                 |          |         |           | Packaging 1 - 35 - B4B |  |
|                                 |          |         |           | Packaging 1 - 36 - B4B |  |
| 260 QC 4                        | 5<br>pcs | 2/27/19 | 0.00 0.00 | QC 4 - 26              |  |
|                                 |          |         |           | QC 4 - 28              |  |
|                                 |          |         |           | QC 4 - 42              |  |
|                                 |          |         |           | QC 4 - 58              |  |
|                                 |          |         |           | QC 4 - 6               |  |
|                                 |          |         |           | QC 4 - 69              |  |
|                                 |          |         |           | QC 4 - 9               |  |
|                                 |          |         |           | QC 4 - 46              |  |
| 270 Packaging 3-1 - Stock - B4B | 5<br>pcs | 2/27/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 2 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 3 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 4 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 5 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 6 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 7 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 8 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 9 - B4B  |  |
|                                 |          |         |           | Packaging 3 - 10 - B4B |  |
|                                 |          |         |           | Packaging 3 - 11 - B4B |  |
|                                 |          |         |           | Packaging 3 - 12 - B4B |  |
|                                 |          |         |           | Packaging 3 - 13 - B4B |  |
|                                 |          |         |           | Packaging 3 - 14 - B4B |  |
|                                 |          |         |           | Packaging 3 - 15 - B4B |  |
|                                 |          |         |           | Packaging 3 - 16 - B4B |  |
|                                 |          |         |           | Packaging 3 - 17 - B4B |  |
|                                 |          |         |           | Packaging 3 - 18 - B4B |  |
|                                 |          |         |           | Packaging 3 - 19 - B4B |  |
|                                 |          |         |           | Packaging 3 - 20 - B4B |  |
|                                 |          |         |           | Packaging 3 - 21 - B4B |  |
|                                 |          |         |           | Packaging 3 - 22 - B4B |  |
|                                 |          |         |           | Packaging 3 - 23 - B4B |  |
|                                 |          |         |           | Packaging 3 - 24 - B4B |  |
|                                 |          |         |           | Packaging 3 - 25 - B4B |  |
|                                 |          |         |           | Packaging 3 - 26 - B4B |  |
|                                 |          |         |           | Packaging 3 - 27 - B4B |  |
|                                 |          |         |           | Packaging 3 - 28 - B4B |  |
|                                 |          |         |           | Packaging 3 - 29 - B4B |  |
|                                 |          |         |           | Packaging 3 - 30 - B4B |  |
|                                 |          |         |           | Packaging 3 - 31 - B4B |  |
|                                 |          |         |           | Packaging 3 - 32 - B4B |  |
|                                 |          |         |           | Packaging 3 - 33 - B4B |  |
|                                 |          |         |           | Packaging 3 - 34 - B4B |  |
|                                 |          |         |           | Packaging 3 - 35 - B4B |  |

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|                  |     |         |           |                        |      |
|------------------|-----|---------|-----------|------------------------|------|
|                  |     |         |           | Packaging 3 - 36 - B4B | DAG  |
| 275 DC - 1 - B4B | 5   | 2/27/19 | 0.00 0.00 | DC - 1 - B4B           | 21   |
|                  | pcs |         |           | DC - 2 - B4B           | 3-35 |
| 280 QC 21 - FG   | 5   | 2/27/19 | 0.00 0.00 | QC 21 - FG - 21        | DAG  |
|                  | pcs |         |           | QC 21 - FG - 70        | 21   |
|                  |     |         |           | QC 21 - FG - 53        | 3-35 |

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg. 138873-3-Grind End Plate flush

Descriptions: D3272 A/R Aluminum Rod 138873-3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: \_\_\_\_\_ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod \_\_\_\_\_ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 9:10 OVEN TEMPERATURE: 320°

FINISH TIME: 9:45 M138997

230 - Wing Walk as per dwg QSI005 4.4 Batch \_\_\_\_\_

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item   | Component Name            | Quantity      | Operation                          | Container |
|---------------|---------------------------|---------------|------------------------------------|-----------|
| D3067-1       | End Plate                 | 10 pcs (2 ea) | 110-Large Fab - Steps - 1          | 5125543   |
| D3219-1       | Plate                     | 10 pcs (2 ea) | 110-Large Fab - Steps - 1          | 5136224   |
| D3272-1       | Step                      | 5 pcs (1 ea)  | 110-Large Fab - Steps - 1          | 5155271   |
| D3065-041     | Step Leg Assembly         | 5 pcs (1 ea)  | 180-Large Fab - Steps - 2 - B4B    | 5150508   |
| D3066-1       | Spacer                    | 10 pcs (2 ea) | 180-Large Fab - Steps - 2 - B4B    | 5128757   |
| MS20600-AD4W4 | Rivet                     | 80 Ea (16 ea) | 180-Large Fab - Steps - 2 - B4B    | 8117999   |
| AN3-35A       | Bolt                      | 10 Ea (2 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| AN4-13A       | Bolt                      | 40 Ea (8 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| AN5-36A       | Bolt                      | 10 Ea (2 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| D2230-3       | Mounting Lug              | 20 pcs (4 ea) | 250-Packaging 1-1 - Pick Kit - B4B |           |
| D2618         | Bushing                   | 10 pcs (2 ea) | 250-Packaging 1-1 - Pick Kit - B4B |           |
| D2856-400-720 | Abrasion Strip 4" X 7.20" | 10 pcs (2 ea) | 250-Packaging 1-1 - Pick Kit - B4B |           |
| D3235-1       | Mounting Lug              | 10 pcs (2 ea) | 250-Packaging 1-1 - Pick Kit - B4B |           |
| D3278-041     | Support Assembly          | 5 pcs (1 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| MS21042L3     | Nut                       | 10 Ea (2 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| MS21042L4     | Nut                       | 40 Ea (8 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| MS21042L5     | Nut                       | 10 Ea (2 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| NAS1149D0363J | Washer                    | 20 Ea (4 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |
| NAS1149D0463J | Washer                    | 80 Ea (16 ea) | 250-Packaging 1-1 - Pick Kit - B4B |           |
| NAS1149D0563J | Washer                    | 20 Ea (4 ea)  | 250-Packaging 1-1 - Pick Kit - B4B |           |

**DART**  
AEROSPACE

Container No: S157323



Part: D350 - 591 - 312

Job No: 189012

Serial No/Batch: S157323

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967

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008348  
8395

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Large Fab - Steps - 1          | D3067-1        | 10       | 239       | 0         |
|                                    | D3219-1        | 10       | 193       | 0         |
|                                    | D3272-1        | 5        | 15        | 0         |
| 180-Large Fab - Steps - 2 - B4B    | D3065-041      | 5        | 0         | 0         |
|                                    | D3066-1        | 10       | 223       | 0         |
|                                    | MS20600-AD4W4  | 80       | 4,067     | 0         |
| 250-Packaging 1-1 - Pick Kit - B4B | AN3-35A        | 10       | 143       | 0         |
|                                    | AN4-13A        | 40       | 1,136     | 0         |
|                                    | AN5-36A        | 10       | 96        | 0         |
|                                    | D2230-3        | 20       | 94        | 0         |
|                                    | D2618          | 10       | 284       | 0         |
|                                    | D2856-400-720  | 10       | 171       | 0         |
|                                    | D3235-1        | 10       | 302       | 0         |
|                                    | D3278-041      | 5        | 19        | 0         |
|                                    | MS21042L3      | 10       | 2,422     | 0         |
|                                    | MS21042L4      | 40       | 2,375     | 0         |
|                                    | MS21042L5      | 10       | 777       | 0         |
|                                    | NAS1149D0363J  | 20       | 1,705     | 0         |
|                                    | NAS1149D0463J  | 80       | 3,271     | 0         |
|                                    | NAS1149D0563J  | 20       | 1,320     | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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**D350-591-312**  
**Job Sheet 189012**



**Part No:** D350-591-312

**Job Qty:** 5 ea

**Part Name:** Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 1/17/19

**Job Tracking No:**

**Due Date:** 2/27/19

**Created By:** Linda Lacelle

**Type:** SOLD

**Description:**

**Note:** DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 5 Ea  |            | 2/27/19  | 0.00      | 0.00    | Start Up Large Fab-4  |           |          |
| 110   | Large Fab          | 5 pcs |            | 2/27/19  | 0.00      | 5.00    | Large Fab 2           |           |          |
| 120   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC9                   |           |          |
| 130   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC5                   |           |          |
| 140   | HandFinish         | 5 pcs |            | 2/27/19  | 0.00      | 0.94    | HandFinish1           |           |          |
| 150   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC7-2                 |           |          |
| 180   | Large Fab          | 5 pcs |            | 2/27/19  | 0.00      | 5.00    | Large Fab 2           |           |          |
| 190   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC10                  |           |          |
| 200   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC5                   |           |          |
| 210   | HandFinish         | 5 pcs |            | 2/27/19  | 0.00      | 0.94    | HandFinish1           |           |          |
| 220   | Powdercoat         | 5 pcs |            | 2/27/19  | 0.00      | 1.49    | Powdercoat1           |           |          |
| 230   | HandFinish         | 5 pcs |            | 2/27/19  | 0.00      | 0.94    | HandFinish3           |           |          |
| 240   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC3                   |           |          |
| 250   | Packaging          | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | Packaging1-3          |           |          |
| 260   | QC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | QC4                   |           |          |
| 270   | Packaging          | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | Packaging3-1          |           |          |
| 275   | DC                 | 5 pcs |            | 2/27/19  | 0.00      | 0.00    | DC                    |           |          |
| 280   | QC21-FG            | 5 Ea  |            | 2/27/19  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod \_\_\_\_\_ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod \_\_\_\_\_ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: \_\_\_\_\_ OVEN TEMPERATURE: \_\_\_\_\_ FINISH TIME: \_\_\_\_\_

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001



### Job BOM

| Part / Item   | Component Name            | Quantity      | Operation             | Container |
|---------------|---------------------------|---------------|-----------------------|-----------|
| D3067-1       | End Plate                 | 10 Ea (2 ea)  | 90-Start up Operation | 9125543   |
| D3219-1       | Plate                     | 10 pcs (2 ea) | 90-Start up Operation | 9125734   |
| D3272-1       | Step                      | 5 Ea (1 ea)   | 90-Start up Operation | 9155271   |
| D3065-041     | Step Leg Assembly         | 5 pcs (1 ea)  | 180-Large Fab         |           |
| D3066-1       | Spacer                    | 10 pcs (2 ea) | 180-Large Fab         |           |
| MS20600-AD4W4 | Rivet                     | 80 Ea (16 ea) | 180-Large Fab         |           |
| AN3-35A       | Bolt                      | 10 Ea (2 ea)  | 250-Packaging         |           |
| AN4-13A       | Bolt                      | 40 Ea (8 ea)  | 250-Packaging         |           |
| AN5-36A       | Bolt                      | 10 Ea (2 ea)  | 250-Packaging         |           |
| D2230-3       | Mounting Lug              | 20 pcs (4 ea) | 250-Packaging         |           |
| D2618         | Bushing                   | 10 Ea (2 ea)  | 250-Packaging         |           |
| D2856-400-720 | Abrasion Strip 4" X 7.20" | 10 pcs (2 ea) | 250-Packaging         |           |
| D3235-1       | Mounting Lug              | 10 pcs (2 ea) | 250-Packaging         |           |
| D3278-041     | Support Assembly          | 5 pcs (1 ea)  | 250-Packaging         |           |
| MS21042L3     | Nut                       | 10 Ea (2 ea)  | 250-Packaging         |           |
| MS21042L4     | Nut                       | 40 Ea (8 ea)  | 250-Packaging         |           |
| MS21042L5     | Nut                       | 10 Ea (2 ea)  | 250-Packaging         |           |
| NAS1149D0363J | Washer                    | 20 Ea (4 ea)  | 250-Packaging         |           |
| NAS1149D0463J | Washer                    | 80 Ea (16 ea) | 250-Packaging         |           |
| NAS1149D0563J | Washer                    | 20 Ea (4 ea)  | 250-Packaging         |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D3067-1        | 10       | 265       | 0         |
|                       | D3219-1        | 10       | 213       | 0         |
|                       | D3272-1        | 5        | 10        | 0         |
| 180-Large Fab         | D3065-041      | 5        | 0         | 0         |
|                       | D3066-1        | 10       | 223       | 0         |
|                       | MS20600-AD4W4  | 80       | 4,576     | 0         |
| 250-Packaging         | AN3-35A        | 10       | 111       | 0         |
|                       | AN4-13A        | 40       | 515       | 0         |
|                       | AN5-36A        | 10       | 114       | 0         |
|                       | D2230-3        | 20       | 34        | 0         |
|                       | D2618          | 10       | 13        | 0         |
|                       | D2856-400-720  | 10       | 138       | 0         |
|                       | D3235-1        | 10       | 23        | 0         |
|                       | D3278-041      | 5        | 26        | 0         |
|                       | MS21042L3      | 10       | 2,207     | 0         |
|                       | MS21042L4      | 40       | 1,763     | 0         |
|                       | MS21042L5      | 10       | 294       | 0         |
|                       | NAS1149D0363J  | 20       | 1,181     | 0         |
|                       | NAS1149D0463J  | 80       | 2,963     | 0         |
|                       | NAS1149D0563J  | 20       | 1,094     | 0         |

### Part Specifications

Specifications could not be found.



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**D350-591-312**  
**Job Sheet 189012**



**Part No:** D350-591-312

**Job Qty:** 5 pcs

**Part Name:** Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 1/17/19

**Job Tracking No:**

**Due Date:** 2/27/19

**Created By:** Linda Lacelle

**Type:** SOLD

**Description:**

**Note:** DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation             | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|-----------------------|----------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                       |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Large Fab - Steps - 1 | 5<br>pcs | 2/27/19    |          | 0.00      | 5.00    | Large Fab - 1         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 10        |           |          |
|       |                       |          |            |          |           |         | Large Fab - 2         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 3         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 4         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 5         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 6         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 7         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 8         |           |          |
|       |                       |          |            |          |           |         | Large Fab - 9         |           |          |
| 120   | QC 9                  | 5<br>pcs | 2/27/19    |          | 0.00      | 0.00    | QC 9 - 10             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 18             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 24             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 43             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 50             |           |          |
|       |                       |          |            |          |           |         | QC 9 - 9              |           |          |
| 130   | QC 5                  | 5<br>pcs | 2/27/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 12             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 17             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 18             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 19             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 22             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 24             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 3              |           |          |
|       |                       |          |            |          |           |         | QC 5 - 42             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 43             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 49             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 51             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 58             |           |          |
|       |                       |          |            |          |           |         | QC 5 - 68             |           |          |

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| Job BOM       |                           |               |                       |                     |
|---------------|---------------------------|---------------|-----------------------|---------------------|
| Part / Item   | Component Name            | Quantity      | Operation             | Container           |
| D3067-1       | End Plate                 | 10 Ea (2 ea)  | 90-Start up Operation | 5125543             |
| D3219-1       | Plate                     | 10 pcs (2 ea) | 90-Start up Operation | 9175734             |
| D3272-1       | Step                      | 5 Ea (1 ea)   | 90-Start up Operation | 5155271             |
| D3065-041     | Step Leg Assembly         | 5 pcs (1 ea)  | 180-Large Fab         |                     |
| D3066-1       | Spacer                    | 10 pcs (2 ea) | 180-Large Fab         |                     |
| MS20600-AD4W4 | Rivet                     | 80 Ea (16 ea) | 180-Large Fab         |                     |
| AN3-35A       | Bolt                      | 10 Ea (2 ea)  | 250-Packaging         | 5101329.            |
| AN4-13A       | Bolt                      | 40 Ea (8 ea)  | 250-Packaging         | 5149283             |
| AN5-36A       | Bolt                      | 10 Ea (2 ea)  | 250-Packaging         | 5133179.            |
| D2230-3       | Mounting Lug              | 20 pcs (4 ea) | 250-Packaging         | 5153673             |
| D2618         | Bushing                   | 10 Ea (2 ea)  | 250-Packaging         | 5146466.            |
| D2856-400-720 | Abrasion Strip 4" X 7.20" | 10 pcs (2 ea) | 250-Packaging         | 5141358             |
| D3235-1       | Mounting Lug              | 10 pcs (2 ea) | 250-Packaging         | 5150059.            |
| D3278-041     | Support Assembly          | 5 pcs (1 ea)  | 250-Packaging         | 5136112X3 5118822X2 |
| MS21042L3     | Nut                       | 10 Ea (2 ea)  | 250-Packaging         | 5130347.            |
| MS21042L4     | Nut                       | 40 Ea (8 ea)  | 250-Packaging         | 5149811             |
| MS21042L5     | Nut                       | 10 Ea (2 ea)  | 250-Packaging         | 5092592.            |
| NAS1149D0363J | Washer                    | 20 Ea (4 ea)  | 250-Packaging         | 5123436             |
| NAS1149D0463J | Washer                    | 80 Ea (16 ea) | 250-Packaging         | 5150216             |
| NAS1149D0563J | Washer                    | 20 Ea (4 ea)  | 250-Packaging         | 5123450.            |

| Job Allocations       |                |          |           |           |
|-----------------------|----------------|----------|-----------|-----------|
| Operation             | Component Part | Required | Inventory | Allocated |
| 90-Start up Operation | D3067-1        | 10       | 265       | 0         |
|                       | D3219-1        | 10       | 213       | 0         |
|                       | D3272-1        | 5        | 10        | 0         |
| 180-Large Fab         | D3065-041      | 5        | 0         | 0         |
|                       | D3066-1        | 10       | 223       | 0         |
| 250-Packaging         | MS20600-AD4W4  | 80       | 4,576     | 0         |
|                       | AN3-35A        | 10       | 111       | 0         |
|                       | AN4-13A        | 40       | 515       | 0         |
|                       | AN5-36A        | 10       | 114       | 0         |
|                       | D2230-3        | 20       | 34        | 0         |
|                       | D2618          | 10       | 13        | 0         |
|                       | D2856-400-720  | 10       | 138       | 0         |
|                       | D3235-1        | 10       | 23        | 0         |
|                       | D3278-041      | 5        | 26        | 0         |
|                       | MS21042L3      | 10       | 2,207     | 0         |
|                       | MS21042L4      | 40       | 1,763     | 0         |
|                       | MS21042L5      | 10       | 294       | 0         |
|                       | NAS1149D0363J  | 20       | 1,181     | 0         |
|                       | NAS1149D0463J  | 80       | 2,963     | 0         |
|                       | NAS1149D0563J  | 20       | 1,094     | 0         |

| Part Specifications                |
|------------------------------------|
| Specifications could not be found. |



| Qty<br>-213 | Qty<br>-214 | Qty<br>-215 | Qty<br>-216 | Qty<br>-311 | Qty<br>-312 | Part Number   | Description                                           |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-------------------------------------------------------|
| X           |             |             |             |             |             | D350-591-213  | <i>Heli-Access-Step™</i> , Short Step – High Skid, LH |
|             | X           |             |             |             |             | D350-591-214  | <i>Heli-Access-Step™</i> , Short Step – High Skid, RH |
|             |             | X           |             |             |             | D350-591-215  | <i>Heli-Access-Step™</i> , Short Step – Low Skid, LH  |
|             |             |             | X           |             |             | D350-591-216  | <i>Heli-Access-Step™</i> , Short Step – Low Skid, RH  |
|             |             |             |             | X           |             | D350-591-311  | <i>Heli-Access-Step™</i> , Long Step – High Skid, LH  |
|             |             |             |             |             | X           | D350-591-312  | <i>Heli-Access-Step™</i> , Long Step – High Skid, RH  |
| 1           |             |             |             |             |             | D3078-041     | STEP ASSEMBLY (HIGH-SHORT, LH)                        |
|             | 1           |             |             |             |             | D3078-042     | STEP ASSEMBLY (HIGH-SHORT, RH)                        |
|             |             | 1           |             |             |             | D3168-041     | STEP ASSEMBLY (LOW-SHORT, LH)                         |
|             |             |             | 1           |             |             | D3168-042     | STEP ASSEMBLY (LOW-SHORT, RH)                         |
|             |             |             |             | 1           |             | D3272-041     | STEP ASSEMBLY (HIGH-LONG, LH)                         |
|             |             |             |             |             | 1           | D3272-042     | STEP ASSEMBLY (HIGH-LONG, RH)                         |
| 2           | 2           | 2           | 2           | 4           | 4           | D2230-3       | MOUNTING LUG                                          |
| 2           | 2           | 2           | 2           | 2           | 2           | D2618         | BUSHING                                               |
| 4           | 4           | 4           | 4           |             |             | D2732-030     | CUSHION                                               |
|             |             |             |             | 2           | 2           | D2856-400-720 | ABRASION STRIP                                        |
| 2           | 2           | 2           | 2           | 2           | 2           | D3235-1       | MOUNTING LUG                                          |
|             |             |             |             | 1           | 1           | D3278-041     | SUPPORT ASSEMBLY                                      |
| 2           | 2           | 2           | 2           | 2           | 2           | AN3-35A       | BOLT                                                  |
|             |             |             |             | 8           | 8           | AN4-13A       | BOLT                                                  |
| 4           | 4           | 4           | 4           |             |             | AN4-15A       | BOLT                                                  |
| 2           | 2           | 2           | 2           | 2           | 2           | AN5-36A       | BOLT                                                  |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1149D0363J | WASHER (AN960JD10)                                    |
| 12          | 12          | 12          | 12          | 16          | 16          | NAS1149D0463J | WASHER (AN960JD416)                                   |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1149D0563J | WASHER (AN960JD516)                                   |
| 2           | 2           | 2           | 2           | 2           | 2           | MS21042L3     | NUT                                                   |
| 6           | 6           | 6           | 6           | 8           | 8           | MS21042L4     | NUT                                                   |
| 2           | 2           | 2           | 2           | 2           | 2           | MS21042L5     | NUT                                                   |
|             |             |             |             | 1           | 1           | *DSI 9410-011 | STEP MODIFICATION KIT                                 |

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.